

Date: Friday, 9/21/2007 1:18:25 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT
 Job Number : 34810
 Estimate Number : 10532
 P.O. Number : *N/A*
 This Issue : 9/21/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : 9/21/2007 Type : SMALL /MED FAB
 Previous Run : 34809
 Part Number : K10003
 Drawing Number : IIN D205-634 REV D
 Project Number : N/A
 Drawing Revision : D
 Material : *N/A*
 Due Date : 10/25/2007 Qty: *9* Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est : 03.01.16 Reformat: Incorporated D205-641-011
 KJ/RF
 Est : J 06-07-25 As per DSI 9344
 JLM
 Est : K 06.11.17 Per K10003 Rev C
 KJ
 Est Rev: L 07.01.12 Document Record for copying bluefile rmv
 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003 CHG 005

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2570 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	<i>333559 (146) - AB 34811 (68)</i>

4.0 D2571 Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	<i>331719</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:18:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34810

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	B32166(6X) - B31720(1X)

B 34748 2X

10/10/07

6.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	B31721(2X) - B34369(8X)

B 34369(8X)

7.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	B34370(8X) - B34751(4X)

B 34751(4X)

8.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	B33469(8X) - B32511(1X)

B 32511(1X)

9.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	B33082(9X)

B 33082(9X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:18:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34810

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2747

Set Screw

HH
HH



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	B33470-

11.0

D2876

Saddle Spacer

HH
HH



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	B29789-

12.0

D2877

Saddle Spacer

HH
HH



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	B32104

13.0

D2968041

Tow Ring

HH
HH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	B30274-

14.0

D35331

Set Screw

HH
HH



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Set Screw

Batch: B28023-

15.0

AN46A

Bolt

HH
HH



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Bolt

Pick:

M104322 (37)
M105057 (107)
B7/10/11 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:18:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34810

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	

16.0 AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-6A	Bolt	M104975-

17.0 AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	M105281-

18.0 AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	M105558-

19.0 AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 320.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	M104746-

20.0 AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	M104745-

CP 8/27/07 (CP)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/10/2016
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:18:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 34810

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN970-4	Washer	M104885

22.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 290.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
29	MS21042L4	Nut (or MS21042-4)	M104683

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: H

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.13

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34810

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.